



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2739

Job Sheet 171942



Part No: D2739

Job Qty: 10 ea

Part Name: 350 I-Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/9/18

Job Tracking No:

Due Date: 2/16/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D2739 REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev: F 10.11.02 as per rev E DD verf: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		2/15/18	0.00	0.00	Start Up Skid tubes-2		
100	Skid tubes	10 pcs		2/15/18	0.00	5.41	Skid tubes-3		
120	Hand Finish	10 pcs		2/16/18	0.00	0.83	Hand Finish1		
130	QC	10 pcs		2/16/18	0.00	0.00	QC5		
140	Packaging	10 pcs		2/16/18	0.00	0.00	Packaging3-1		
150	QC21-SA	10 Ea		2/16/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jlg DT8162 as per Dwg D2739 3-Descriptions: Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends.
140 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-5-108	Extrusion I-Beam Thin	10 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation B145248	D2600-5-108	10	128	0

DART
AEROSPACE
S040982

Dart Aerospace Ltd.

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350 I-Beam

PART NO: D2739
Original Serial #: S040982

Revision:

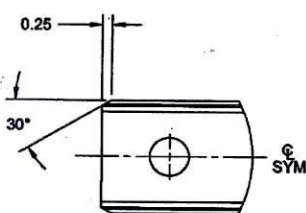
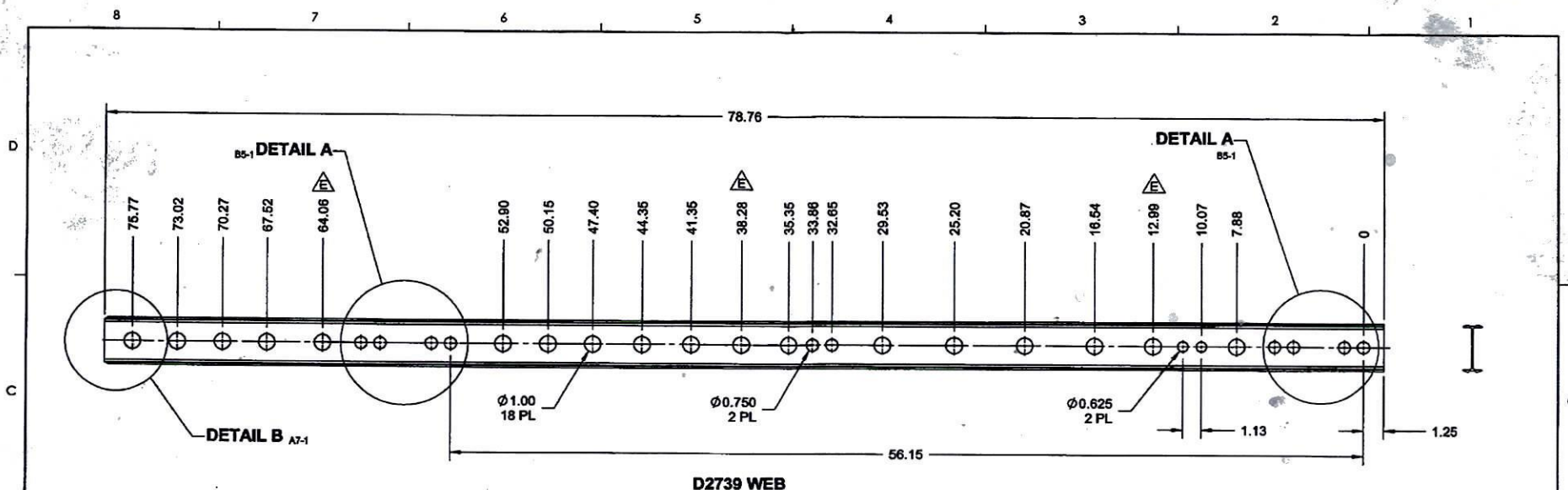
Operation: Start up Operation 02/09/18

Change No:

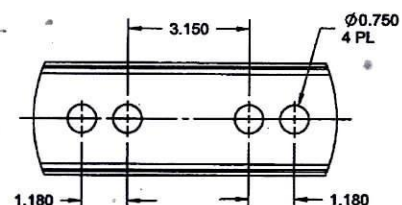
Job No: 171942

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Web	78.760Inches ± 0.030	78.790 78.730		
2	Web	1.180Inches ± 0.010	1.190 1.170		
3	Web	3.150Inches ± 0.010	3.160 3.140		
4	Web	1.180Inches ± 0.010	1.190 1.170		
5	Web	0.250Inches ± 0.030	0.280 0.220		
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle	
7	Web	1.250Inches ± 0.030	1.280 1.220		
8	Web	7.880Inches ± 0.030	7.910 7.850		
9	Web	10.070Inches ± 0.030	10.100 10.040		
10	Web	12.990Inches ± 0.030	13.020 12.960		
11	Web	16.540Inches ± 0.030	16.570 16.510		
12	Web	20.870Inches ± 0.030	20.900 20.840		
13	Web	25.200Inches ± 0.030	25.230 25.170		
14	Web	29.530Inches ± 0.030	29.560 29.500		
15	Web	32.650Inches ± 0.030	32.680 32.620		
16	Web	33.860Inches ± 0.030	33.890 33.830		
17	Web	35.350Inches ± 0.030	35.380 35.320		
18	Web	38.280Inches ± 0.030	38.310 38.250		
19	Web	41.350Inches ± 0.030	41.380 41.320		
20	Web	44.350Inches ± 0.030	44.380 44.320		
21	Web	47.400Inches ± 0.030	47.430 47.370		
22	Web	50.150Inches ± 0.030	50.180 50.120		
23	Web	52.900Inches ± 0.030	52.930 52.870		
24	Web	64.060Inches ± 0.030	64.090 64.030		
25	Web	70.270Inches ± 0.030	70.300 70.240		
26	Web	73.020Inches ± 0.030	73.050 72.990		
27	Web	75.770Inches ± 0.030	75.800 75.740		
28	Web	56.150Inches ± 0.030	56.180 56.120		

Plex 2/9/18 11:42 AM Dart.Gagnon.Michelle



DETAIL B
SCALE 3X



DETAIL A
SCALE 3X

RELEASED
2010-11-01

- NOTES:
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 8.1
 - 7) WEIGHT: 3.41 lbs

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. ~~171264~~ *171 942*

FEB 07 2018

DESIGN	DS	DESCRIPTION	BY	DATE
DRAWN	<i>JP</i>	DART AEROSPACE USA, INC.		
CHECKED	<i>JP</i>	PORT HADLOCK, WA		
MFG. APPR.	<i>JP</i>	DRAWING NO. D2739	REV. E	
APPROVED	<i>JP</i>	TITLE WEB	SHEET 1 OF 1	
DE APPR.	<i>JP</i>	SCALE NTS		
DATE	10.10.08	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.		